

Date: Wednesday, 10/09/2008 3:40:58 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 41939			Part Number	: D33193		
Estimate Number	: 10606			Drawing Number	: D3319 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/09/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /			Due Date	: 30/09/2008		
Previous Run	: 41799			Qty:	6 Um: Each		
Written By	:						
Checked & Approved By	: JLD 08.9.10						
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025 SHEET .048
		Comment: Qty.: 3.4150 sf(s)/Unit Total: 20.4901 sf(s) 1010/1025/A21/6aA SHEET .048" Thick Batch: 109022 R 8-9-12
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: R R 8-9-12 Prog Rev: R ⑧
		2-Deburr if necessary R 8-9-12
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 R 8-9-12
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Soebelis (xs)
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Done at step 22.2 S skts
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41939		Part Number: D33193
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form using DT8326 & DT8261 as per Dwg D3319 Rev: B		S 08/09/16 (8)
7.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		S 08/09/17 (8)
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B		A 8-9-18 (X8)
Qty	Part Number	Description
A/R	N/A	7560 Hardcoat Rod
9.0	QC10	VISUAL INSPECTION OF GROUND WELDS
Comment: VISUAL INSPECTION OF GROUND WELDS		S 08/09/18 (X8)
10.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		S 08/09/18 (X8)
11.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		M 106442
START TIME:	11:00 AM	
OVEN TEMPERATURE:	320°F	
FINISH TIME:	11:30 AM	
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		F 1 08/09/18 (8)
13.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.		496 S 09/18 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 3:40:58 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 41939

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: UAG

8/9/18

MF 08-09-19

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41939
Description: Wearplate	Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

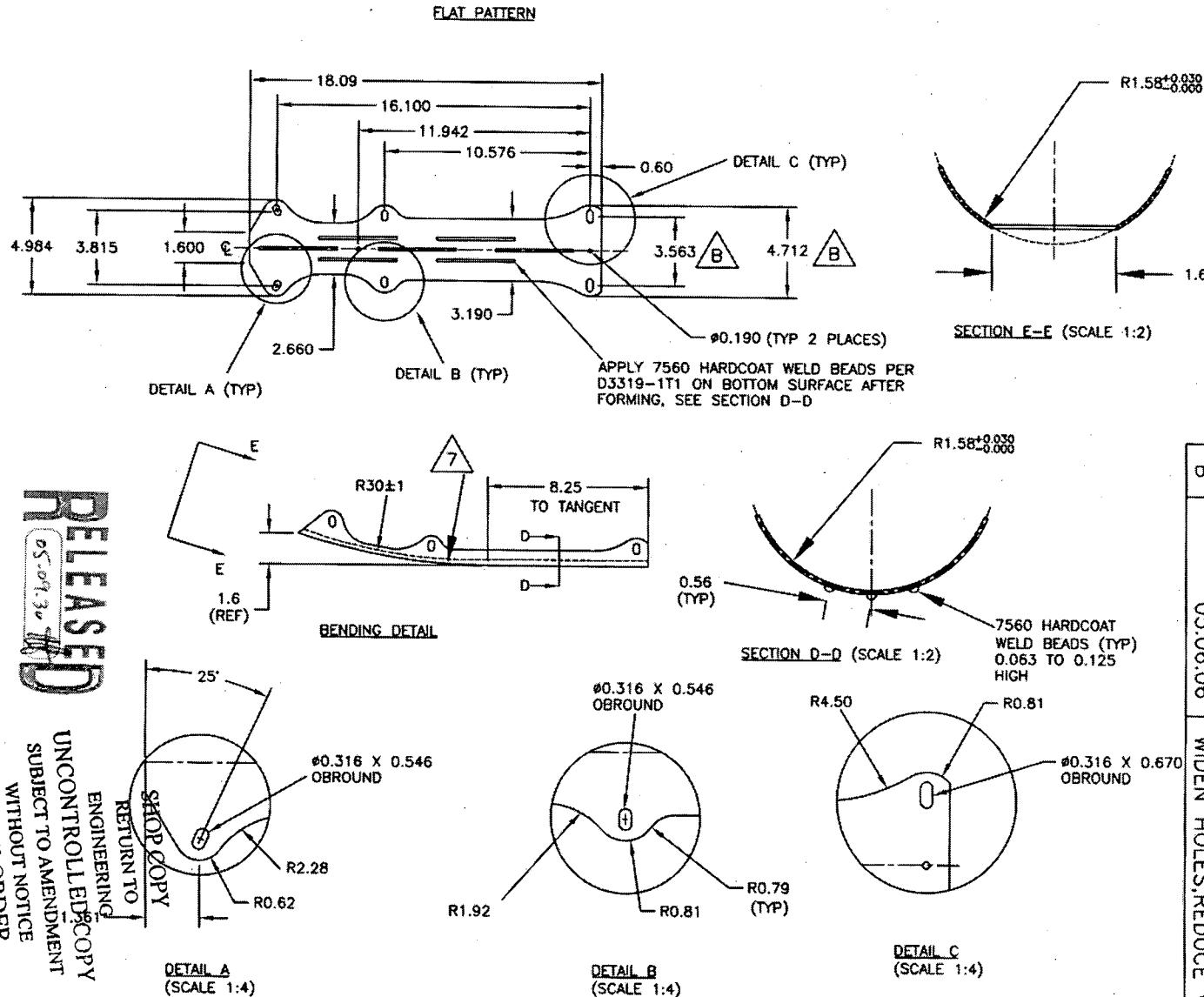
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52 X				
74.420	+/-0.010	74.400 V				
62.770	+/-0.010	62.770 X				
52.890	+/-0.010	52.890 X				
30.790	+/-0.010	30.790 X				
8.690	+/-0.010	8.690 X				
.60	+/-0.030	.598 X				
2.690	+/-0.010	2.706 X				
2.940	+/-0.010	2.949 X				
3.527	+/-0.010	3.519 X				
4.518	+/-0.010	4.515 X				
Ø0.190	+0.005/-0.001	.194 X				
2.940	+/-0.010	2.948 X				
2.940	+/-0.010	2.949 X				
2.690	+/-0.010	2.691 X				
5.063	+/-0.010	5.060 X				
6.163	+/-0.010	6.159 X				
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	318 X 611 *				
0.048	+/-0.010	.049 *				

Measured by:	FB	Audited by:	J	Prototype Approval:	N/A
Date:	8-9-15	Date:	08/09/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	RE

DART

DESIGN P1	DRAWN BY P1	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06	DRAWING NO. D3319	REV. B
		SHEET 1 OF 5
		SCALE 1:8
A	04.09.24	TITLE WEARPLATE
B	05.06.06	NEW ISSUE



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

NO. *4931*

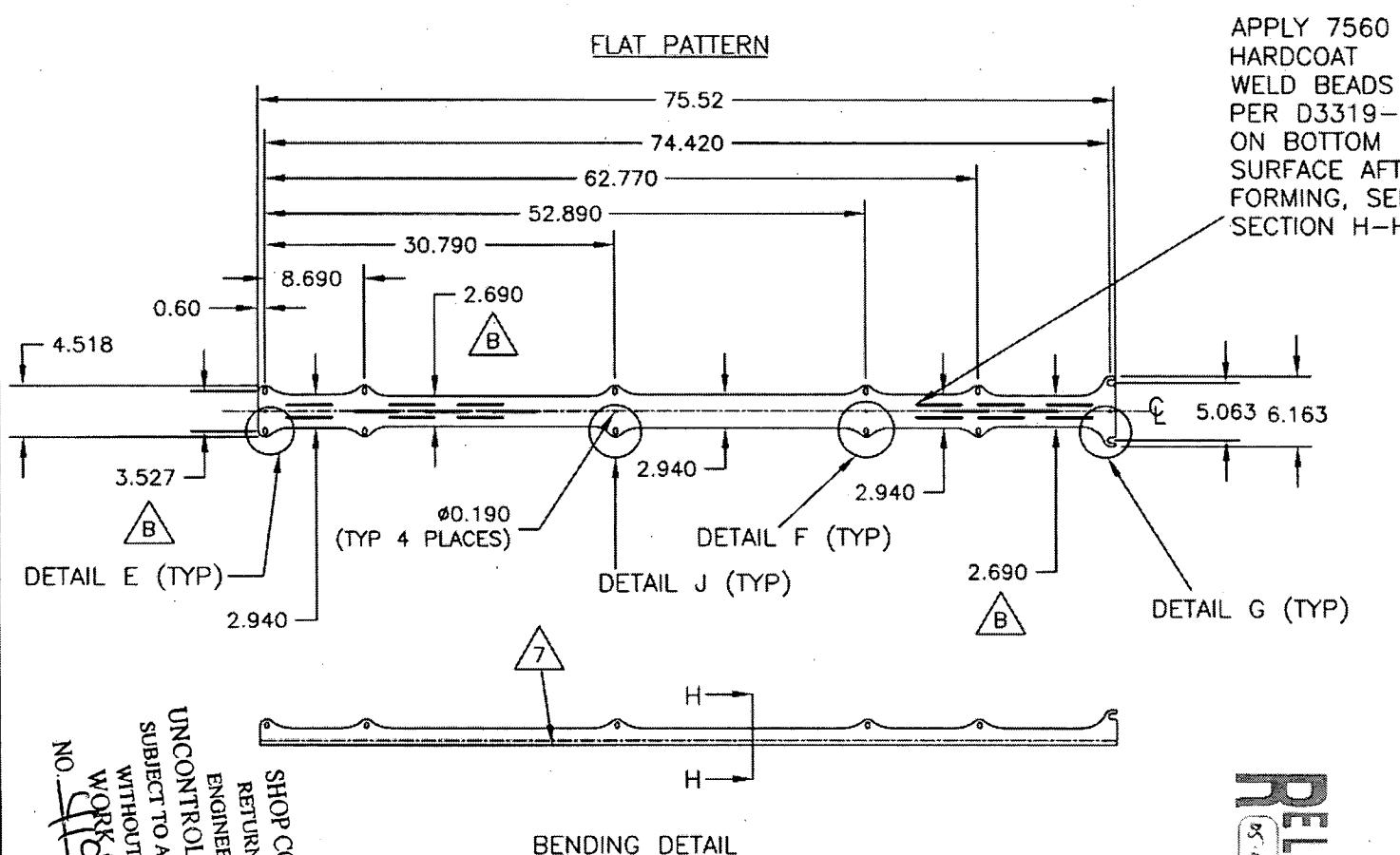
RELEASED
05.09.24
UNCONTROLLED BY DART AEROSPACE LTD
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASER

DART

DESIGN D3319-3T1	DRAWN BY P.H.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 2 OF 5 SCALE 1:15

RELEASED



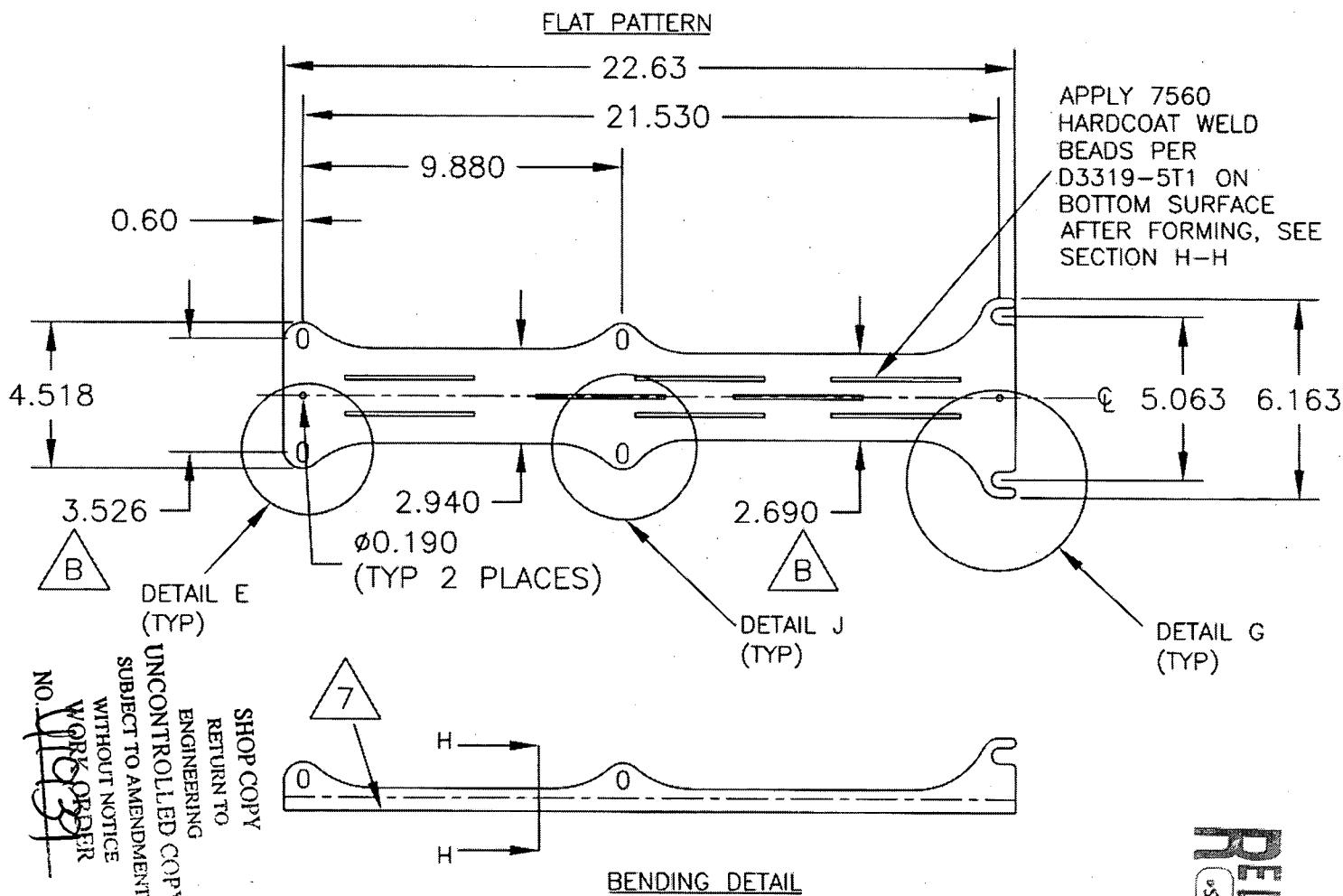
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *[Signature]*

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

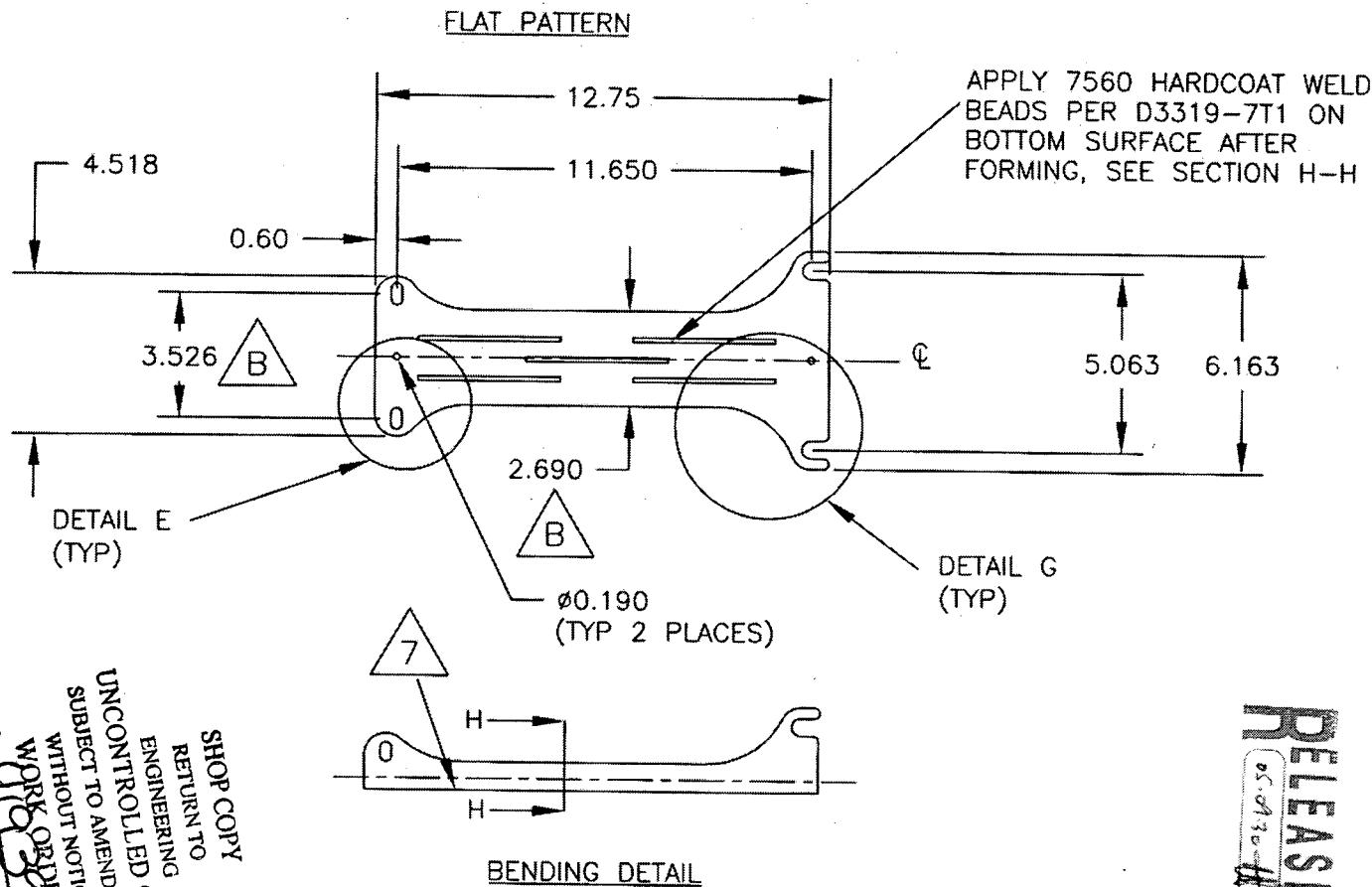
DESIGN D31	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	SCALE 1:5

RELEASED
05.04.30**D3319-5 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN PH	DRAWN BY GH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3319
DATE		SHEET 4 OF 5
05.06.06		SCALE 1:5

RELEASED
05.06.06

NO. 050134

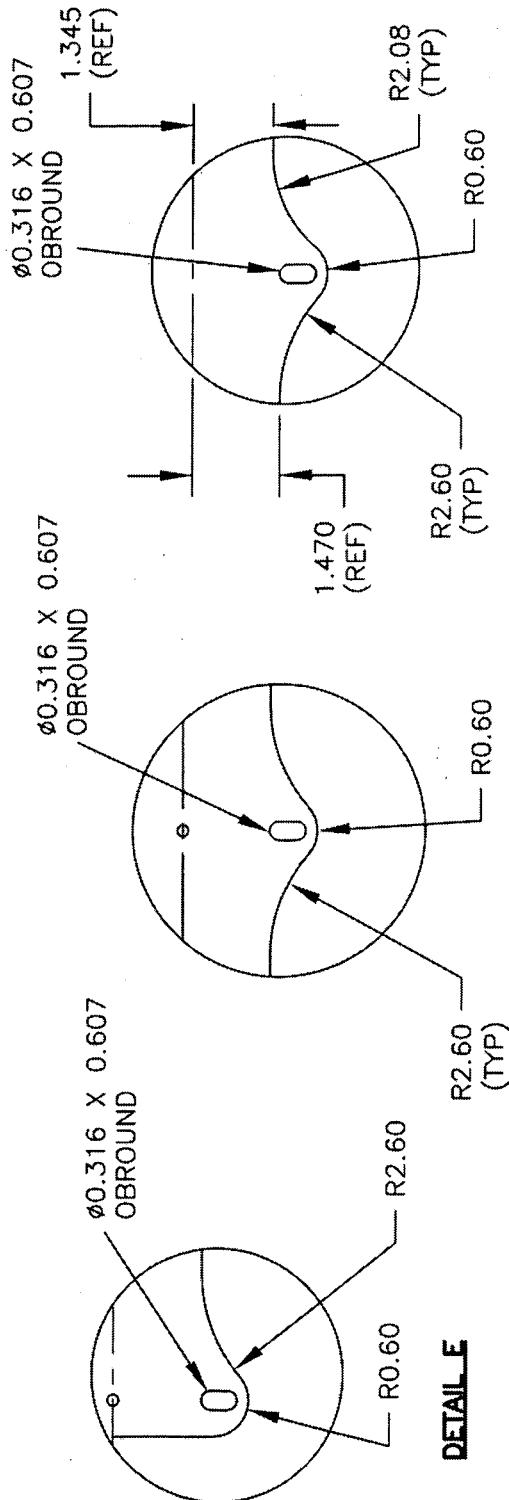
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

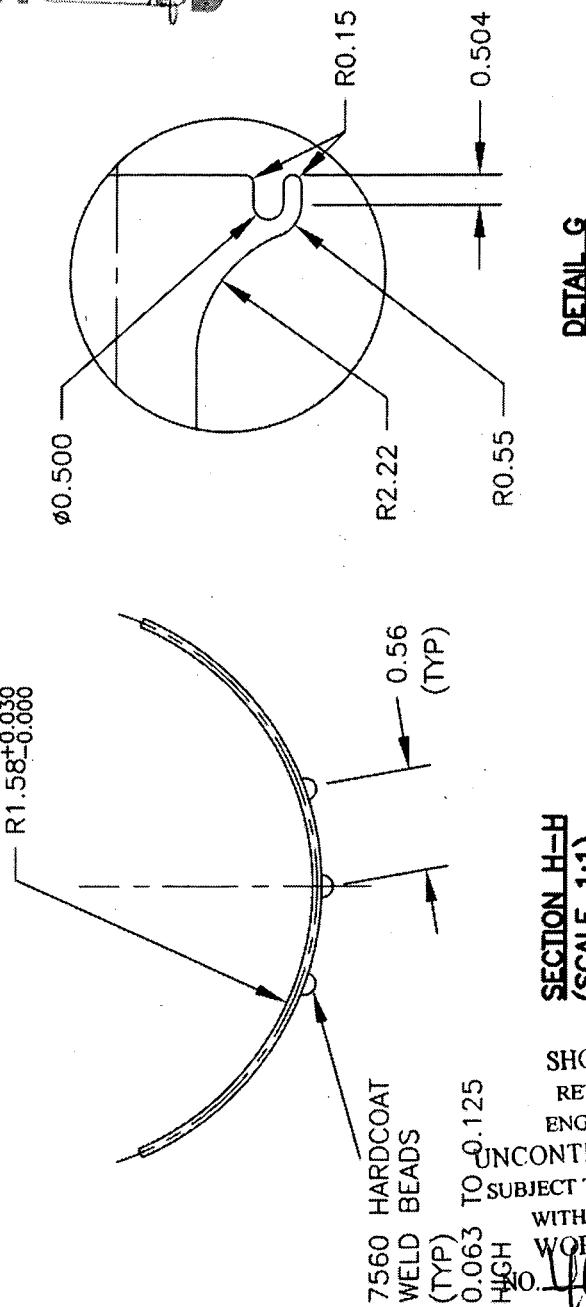
DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3



RELEASED
05.09.30

DETAIL J



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